

Work Order ID 60874

Monday, July 26, 2010 12:27:42 PM



Page 1

Item ID: D4091-1

Revision ID:

Item Name: Mounting Lug

Start Date: 7/26/2010 Start Qty: 12.00

Required Date: 8/3/2010 Req'd Qty: 12.00

Reference:

Accept

Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4091

A

0.00

100



Bandsaw

Jeaspa Bandsaw

0.00

Memo

CUT BLANK 1.450" LONG

0.00

0.00

110



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA920 AND DWG

FOLIO REV: AA

DWG REV: A

DEBURR

Setup Start

Stop

Run

Start

Stop

12 0

12 0

cmf 10/07/27

88 10/07/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept



Setup Start



Stop



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Required Date: 8/3/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				12	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				12	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				11	10	08 03	(12)

28 10/07/29

DJP
10/07/29

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

Powder Coating

White Gloss (Ref: 4.3.5.1) per OSI005 4.3-Alum

Memo

START: 11:50
 OVENT: 320°
 FINISH: 12:20

0.00

0.00

12

BR 10-8-11

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

12

d

=) M 10/08/01

170



Packaging

Packaging

Identify as per dwg & Stock Location: 460

Memo

0.00

0.00

C. 10/8/05 (12)

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/08/05

MF 10-08-05

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Picklist Print

Monday, July 26, 2010 12:27:46 PM

Page 1

Work Order ID: 60874



Parent Item: D4091-1

Parent Item Name: Mounting Lug

Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2423

Manufactured No

100 f

393.6932 0.1251

1.580211



Lug Extrusion



Location

Loc Qty

Loc Code

MAT06

393.6931695

43722

180

→ 45800

213.693169

1.5802 mk 10/07/27

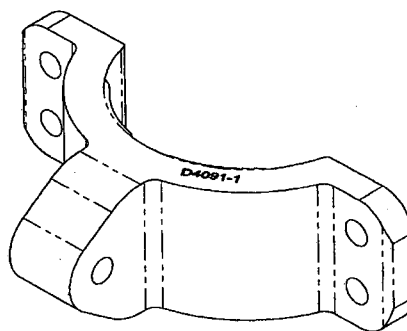
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D4091-1 MOUNTING LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT: 0.31 lbs

SHOP COPY
RETURN TO
ENGINEERING.
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60874

BA 10-7-24

RELEASED
2010-04-28
W

A		NEW ISSUE		CP	10.03.29
REV.		DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	CP				
CHECKED		DRAWING NO.	D4091	REV. A	
MFG. APPR.				SHEET 1 OF 2	
APPROVED		TITLE	MOUNTING LUG	SCALE	
DE APPR.				NTS	
DATE	10.03.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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